

Work Order ID 69628

Thursday, May 12, 2011 3:19:06 PM



Page 1

Item ID: D3640-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Belt Guide

Start Date: 5/12/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

11-05-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3640	Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.700 " long

11/06/08

10

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1 Punch

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA670 & Dwg D3640 Rev: ☐ 2-Deburr and Blend
rad intersection with deburring tool.

Issue P10: 14260

C2 11/06/09 10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Dan's Precision Machine as per dwg D3640 REV.A

11/11/22 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69628

Thursday, May 12, 2011 3:19:06 PM



Page 2

Item ID: D3640-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Belt Guide

Start Date: 5/12/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC Inspect parts - second check

0.00

5 w/06/28



QC

Memo

0.00

Quality Control

(10)

140

Identify as per dwg & Stock Location: ST244

0.00



Packaging

Memo

0.00

Packaging

CZ 11/06/28 (10)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 (10)

11-06-28
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:19:12 PM

Page 1

Work Order ID: 69628

Parent Item: D3640-1

Parent Item Name: Belt Guide

Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB0.75X1.250		Purchased	No			100	f	8.0000	0.4	3.368421			



Delrin Bar



Location

Loc Qty

Loc Code

MAT055

8

14535

8

~~2.5~~ 4 11/06/08
4.0

D3640-1P

Rec'd 5/27 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

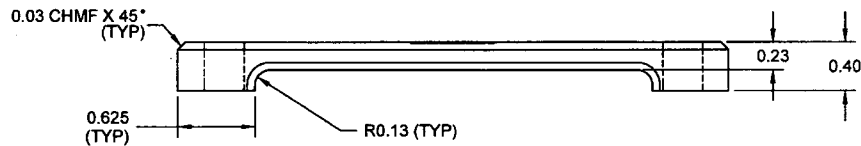
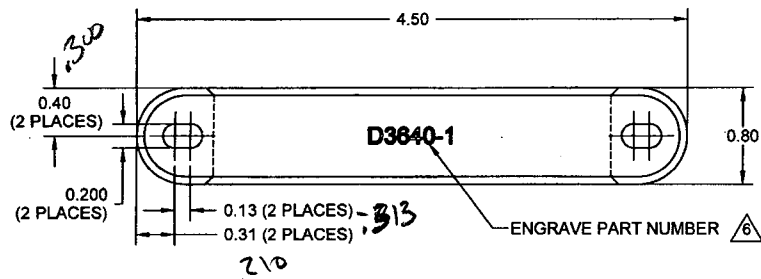
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

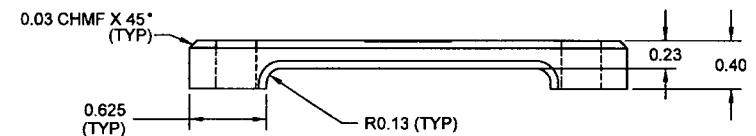
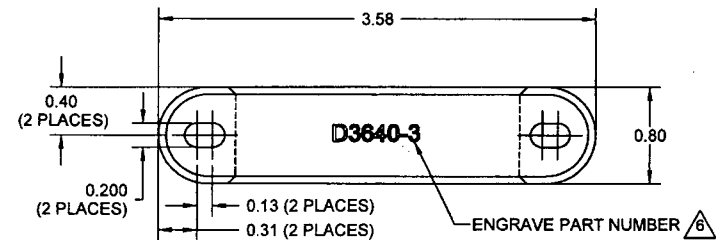
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09628

11-05-12



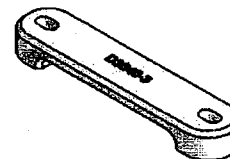
D3640-1 BELT GUIDE
(WAS GENEVA P/N G10605-1)



D3640-3 BELT GUIDE
(WAS GENEVA P/N G10605-2)

RELEASED
07.09.01

- NOTES:**
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
 - 7) WEIGHT: 0.03 lbs



A	NEW ISSUE; REPLACES G10605	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.27		

DART AEROSPACE USA, INC.		REV. A
PORT HADLOCK, WA		SHEET 1 OF 1
DRAWING NO.	D3640	SCALE
TITLE	BELT GUIDE	1:1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To:  DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 27-Jun-11

Purchase Order : PO14260

Packing Slip : 10529

Part Number : D3640-1revA

Quantity : 10

8 u/c b/s

Per: _____

For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE

P.O.: PO14260

W/O: _____

Part #: D3640-1 rev A

Belt Guide _____

Qty: 10

1 of 1